

Split

Work Order ID 100855-2

100855

Page 1

May-01-13 7:30:19 AM

Item ID: D3296-041

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly

Start Date: 5/09/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/09/13

Req'd Qty: 2.00

2

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

ML5

Date: 13-05-03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3296

B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

9:00

M123480

3x
13/05/12

3

3x mf 13/05/27

Work Order ID 100855

May-01-13 7:30:19 AM

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Page 2

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Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

5x 4 ll 13/05/27

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

1x

PTD
13/05/28

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAG
27
0.00

1

160 → ID + STOCK

ST. 2/8

SP 1x 13-5-30

170 → QC 21

13/5/31

UMF
13-5-30

DQA: 13/2 Date: 13/06/07

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 13/6/07 Date: 13/6/07Work Order update only ☐

Work Order: <u>100855</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3296-041</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2691</u>		Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	<u>13/05/27</u>	<u>140</u>	<u>1</u>	<u>1 Door Label</u> <u>+ sand</u> <u>was glue at the</u> <u>wrong place</u> <u>R.C. need template</u> <u>for work / lack of</u> <u>tooling</u>	<u>u</u> <u>13/5/27</u>	<u>Scuff</u> <u>Repaint door</u> <u>Start time: 2:30</u> <u>Temp: 320°F</u> <u>Finish time: 3:00</u> <u>m12348</u>	<u>13/05/27</u> <u>13528</u>	<u>13/05/28</u>	 <u>13/05/28</u>
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Picklist Print

May-01-13 7:30:18 AM

Page 1

Work Order ID: 100855
Parent Item: D3296-041
Parent Item Name: Door Assembly

Start Date: 5/09/13
Start Qty: 2.00

Required Date: 5/09/13
Required Qty: 2.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	6.0000	1	2		5/13/05/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		6							
				88458		2							
				95880		4							
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	7.0000	1	2		5/13/05/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		7							
				90221		3							
				95970		4							
D3296-1 Door Panel		Manufactured	No			100	Each	3.0000	1	2		5/13/05/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		3							
				93813		3							
D3296-3 Door Panel		Manufactured	No			100	Each	0.0000	1	2		5/13/05/22	
MS20470AD4-6 Rivet, Universal Head		Purchased	No			100	Each	1,562.0000	1	2		5/13/05/28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		19							
				118927		19							
				ST336		1028							
				124231		1028							
				ST505		515							
				123021		515							

B99664 (3x)

Picklist Print

May-01-13 7:30:18 AM

Page 2

Work Order ID: 100855
Parent Item: D3296-041
Parent Item Name: Door Assembly

Start Date: 5/09/13

Required Date: 5/09/13

Start Qty: 2.00

Required Qty: 2.00

D2137 Manufactured No
Decal - No Step

140 Each 27.0000

1

2

EP 5/13/05/27

Location

Loc Qty

Loc Code

GA

27

89266

8

90854

9

99733

10

3

D2419 Manufactured No
Handle

140 Each 13.0000

1

2

EP 5/13/05/27

Location

Loc Qty

Loc Code

GA

13

95832

5

98389

2

99703

6

21

D2462 Manufactured No
Seal

140 f 499.8338

2.8166

5.6332

EP 5/13/05/27

Location

Loc Qty

Loc Code

ST403

499.8338

48530

13.7336

98802

486.1002

8.4498

MS20470AD4-4 Purchased No
Rivet, Universal Head

140 Each 6,368.0000

25

50

EP 5/13/05/22

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

391

116188

68

118614

135

122027

188

ST506

5976

125268

5976

75

May-01-13 7:30:19 AM

Shop Packet Print

Page 2

Picklist Print

May-01-13 7:30:19 AM

Page 3

Work Order ID: 100855
Parent Item: D3296-041
Parent Item Name: Door Assembly

Start Date: 5/09/13

Required Date: 5/09/13

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J

Purchased

No

140

Each

66.0000

1

2

Washer

Location

Loc Qty

Loc Code

ST293

66

123900

66

EB 3/05/27
M125464
(3x)

May-01-13 7:30:19 AM

Shop Packet Print

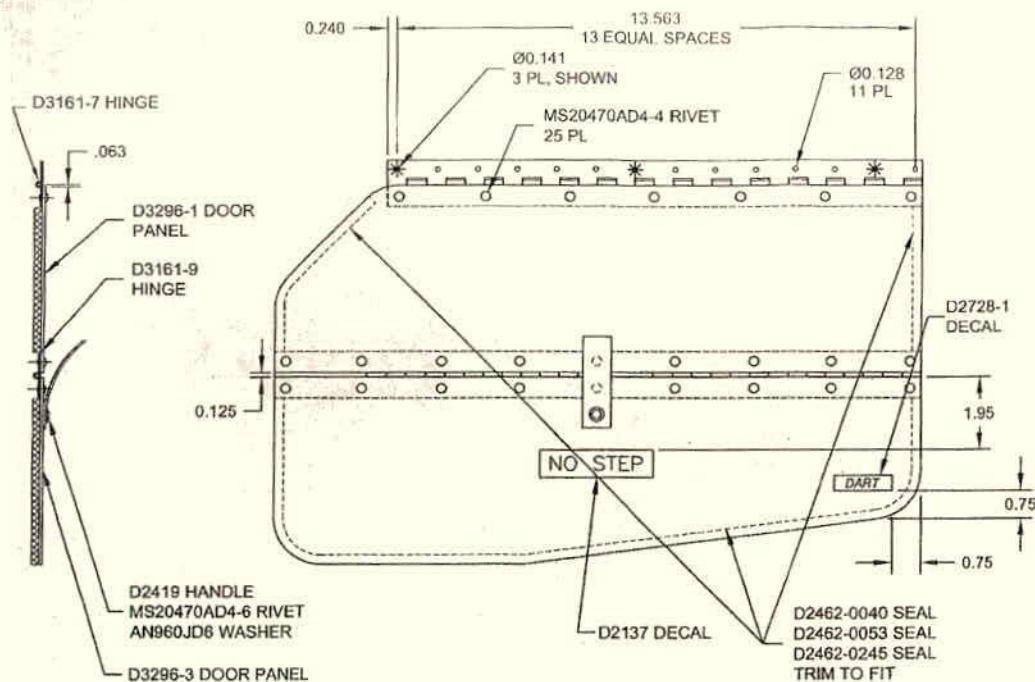
Page 3

D

C

B

A



D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.6" LONG HANDLE

REV	PART NUMBER	DESCRIPTION
041	C 3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

100855 MLS
1305-03

RELEASED
2012-11-21
MPO

B	ADD D3296-041B, REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	99		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	AND		
APPROVED	AND		
DE APPR.	AND		
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3296

REV. B

SHEET 1 OF 3

TITLE

DOOR ASSEMBLY

SCALE

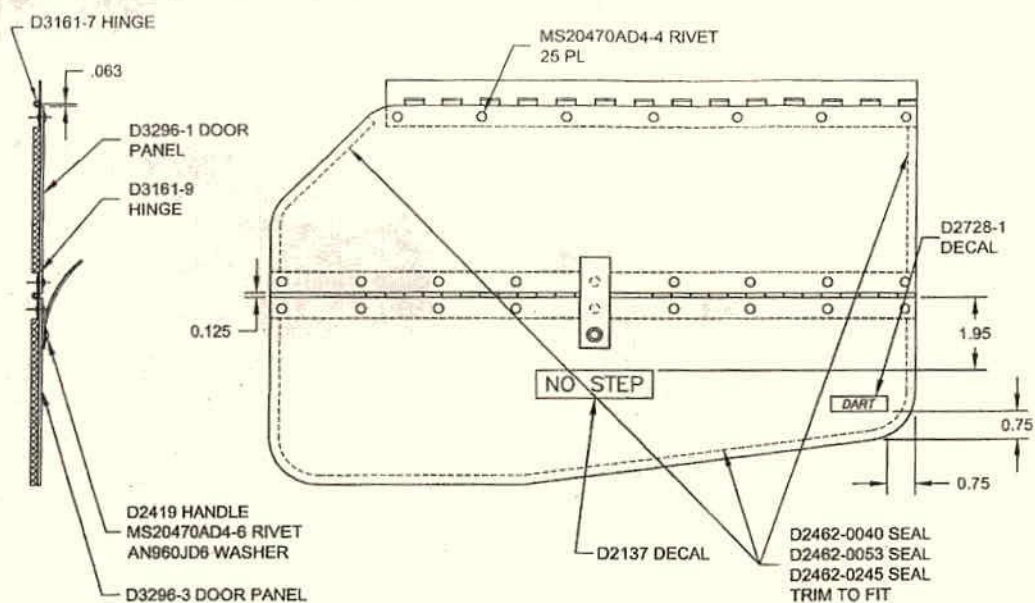
NTS

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10085

QTY	PART NUMBER	DESCRIPTION
041B		
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



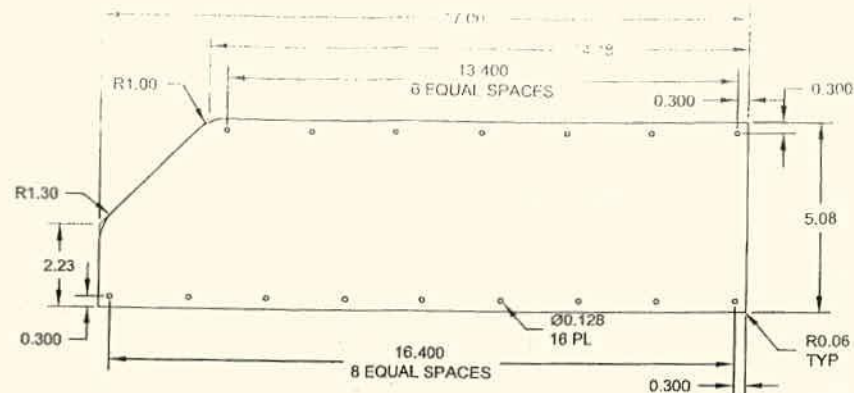
D3296-041B DOOR ASSEMBLY, BLANK

- D3296-041B NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.8 lbs
 - 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
 - 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

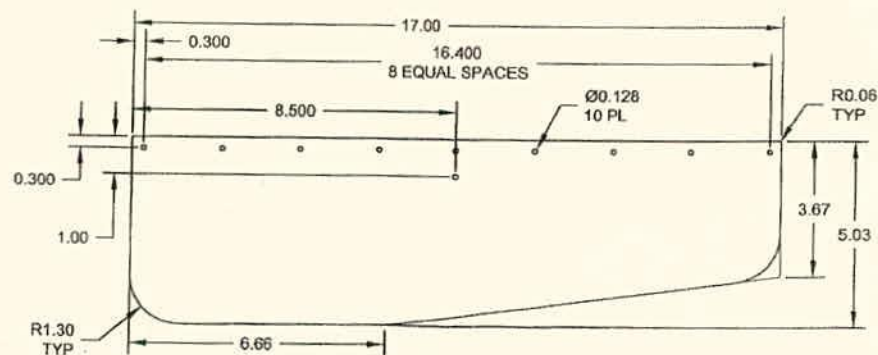
RELEASED
2012-11-21
AND

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO. D3296	REV. B
MFG. APPR.	99		SHEET 2 OF 3
APPROVED	99	TITLE	SCALE
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100855



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

RELEASED
2012-11-21
WMD

D3296-1/3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	91	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3296	SHEET 3 OF 3
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